

Date: Tuesday, 6/19/2007 4:39:56 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 33012
 Estimate Number : 12902
 P.O. Number :
 This Issue : 6/19/2007 S.O. No. :
 Prsht Rev. : NC
 First Issue : 1 / Type : SMALL /MED FAB
 Previous Run :
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A New Issue 07.06.12 EC

Drawing Name : WEARPLATE
 Part Number : D350813
 Drawing Number : D3508 U/R
 Project Number : N/A
 Drawing Revision : U/R
 Material :
 Due Date : 6/25/2007

PROTOTYPE
 PLEASE RETURN ALL ISSUED
 DATA TO ENGINEERING
 PH 07-06-20

Qty: 2 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S20GA 304/316 .040 Sheet



Comment: Qty.: 0.1806 sf(s)/Unit Total : 0.3612 sf(s)
 304 SS .038" THK
 (M304S20GA)
 Batch: M104646

**CERTIFICATE OF CONFORMITY
 REQUIRED**

SAN 07/06/20

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3508
 Dwg Rev: U/R
 Prog Rev: U/R
 2-Deburr if necessary

SAN 07/06/20

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAN 07/06/20

4.0 QC8 SECOND CHECK



**ENGINEERING
 APPROVAL**

Comment: SECOND CHECK

OK PH 07.06.21

5.0 BRAKE NC NC BRAKE


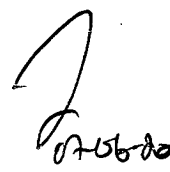
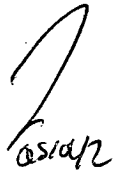



Comment: NC BRAKE
 1-Form on brake using DT8326 and DT8261 as per Dwg D3508

SB 07/06/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 09/07/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/20	2.0	One part Scrap, Used wrong Dxf "D3508-13Fjig instead of using D3508-13"		Scrap destroy replace use the right DXF <u>muFF</u>	SAD 07/06/20			

NOTE: Date & initial all entries

Date: Tuesday, 6/19/2007 4:39:56 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 33012

Part Number: D350813

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

E 07-06-21

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m 10/601

BR/M.A 07-06-21 (2)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

E 07-06-21

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FOR ENGINEERING USE ONLY

E 07-06-22

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/07/09

Job Completion



U 07-07-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

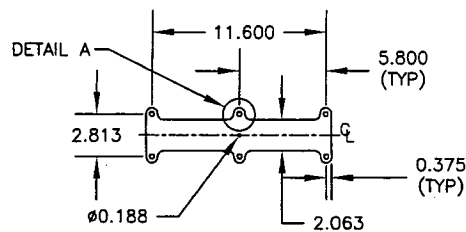
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

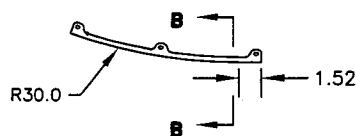
NOTE: Date & initial all entries

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING

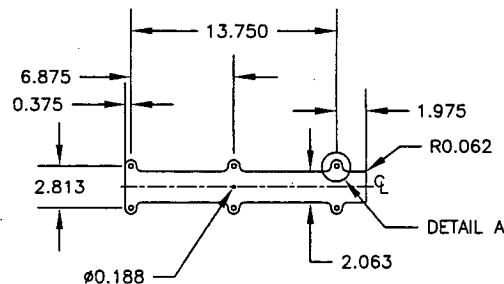
R4 07.06.20



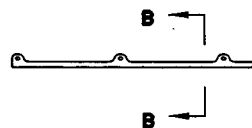
D3508-1 FLAT PATTERN



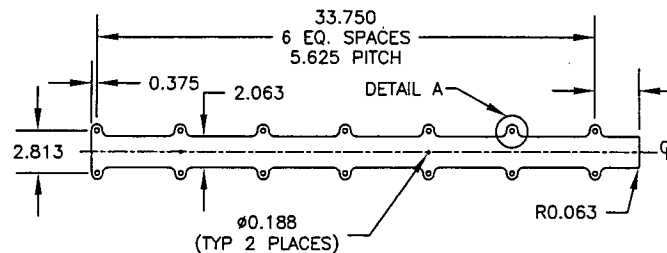
D3508-1 BENDING DETAIL
(MAKE FROM D3508-1F)



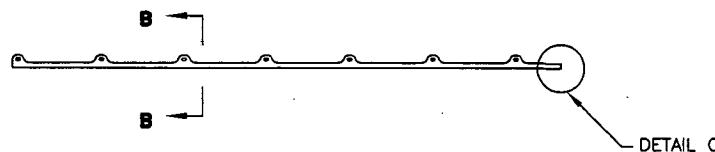
D3576-7F FLAT PATTERN



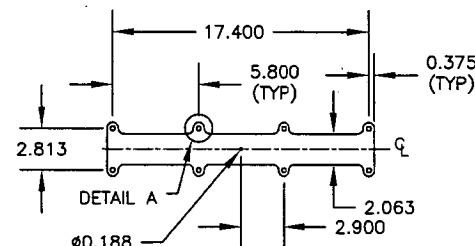
D3576-7 BENDING DETAIL
(MAKE FROM D3576-7F)



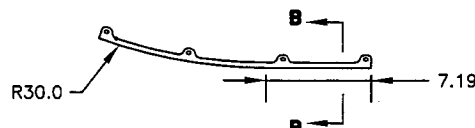
D3508-3 FLAT PATTERN



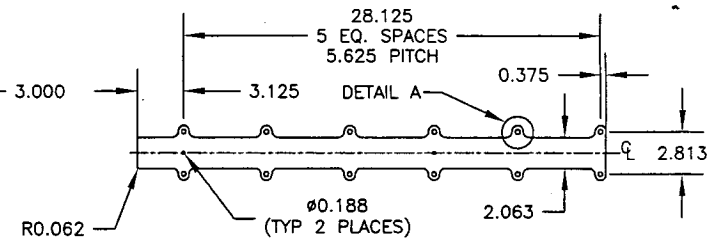
D3508-3 BENDING DETAIL
(MAKE FROM D3508-3F)



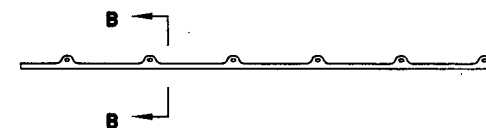
D3508-9F FLAT PATTERN



D3508-9 BENDING DETAIL
(MAKE FROM D3508-9F)



D3508-5 FLAT PATTERN



D3508-5 BENDING DETAIL
(MAKE FROM D3508-5F)

UNDER REVIEW
R4 07.06.20

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART MATERIAL SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) PART IS SYMMETRICAL ABOUT CENTERLINE

C	07.04.20	ADD -9/-11/-13, MOVE TAB OUTBOARD
B	06.10.27	CHANGE STAINLESS STEEL, WIDEN TAB
A	06.04.21	NEW ISSUE
DESIGN	R4	DRAWN BY R4
CHECKED		APPROVED
DATE	07.04.20	TITLE
		WEARPLATE
		SCALE
		1:8

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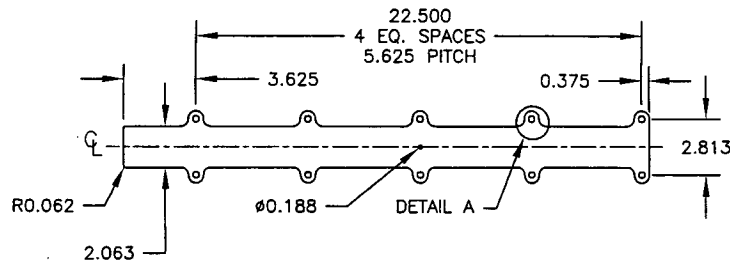
DART DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. D3508 REV. C SHEET 1 OF 2

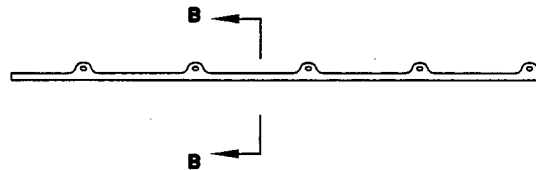
NO. 33012
WORK ORDER
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
SHOP COPY
RETURN TO
ENGINEERING

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING

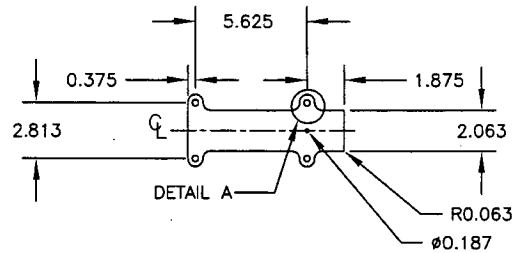
07.06.20



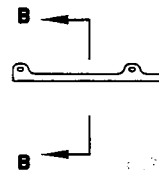
D3508-11F FLAT PATTERN



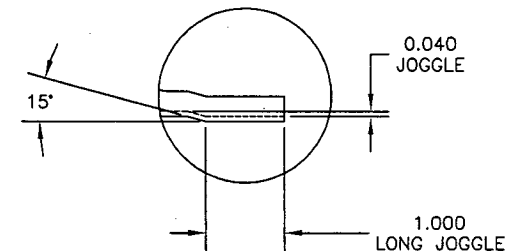
D3508-11 BENDING DETAIL
(MAKE FROM D3576-11F)



D3508-13F FLAT PATTERN



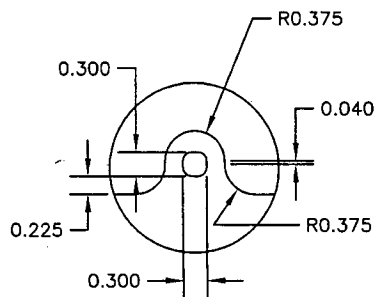
D3508-13 BENDING DETAIL
(MAKE FROM D3508-13F)



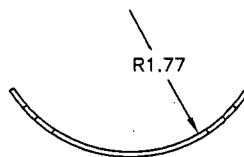
DETAIL C
(SCALE 1:2)

UNDER REVIEW

07.06.20



DETAIL A
(SCALE 2:3)



SECTION B-B
(SCALE 2:3)

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART MATERIAL SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) PART IS SYMMETRICAL ABOUT CENTERLINE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33012

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		DATE 07.04.20	TITLE WEARPLATE	
				REV. C SHEET 2 OF 2 SCALE 1:6

DART AEROSPACE LTD		Work Order: 33012
Description: LUBRICATE		Part Number: D350813
Inspection Dwg: D3508 Rev: V/R		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 2.813	+/- 0.010	2.810	✓		Vern	
B 6.375	+/- 0.010	6.375	✓		Vern	
C 2.063	+/- 0.010	2.070	✓		Vern	
D 5.625	+/- 0.010	5.624	✓		Vern	
E 0.040	+/- 0.010	0.036	✓		Vern	
F 1.875	+/- 0.010	1.880	✓		Vern	
G Ø 0.188	+ 0.005 - 0.001	0.188	✓		Vern	
H 0.300	+/- 0.010	0.302	✓		Vern	
I 0.300	+/- 0.010	0.304	✓		Vern	
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: SMD	Audited by: RH	Prototype Approval:	N/A
Date: 07/06/20	Date: 07.06.21	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	

Receiving Report

Date:

Batch No:

Supplier:

Dart P/O:

Packing Slip: Yes ☒ No

Invoice: Yes ☐ No ☐

Receipt: Cash Cr.

Release Note Attached: Yes ☒ No

Waybill Attached: Yes ☐ No ☐

Shipment Complete: Yes ☒ No ☐

QC6 Inspection yes 1/5 0-100

Work Order 1015400

N/A

N/A

N/A

N/A

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

Production/Admin:

Case

Received/Costing

initial

Location

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

[illegible]

FRAIS D'ADMINISTRATION DE 1½% PAR MOIS (18% PAR ANNÉE) SUR COMPTE PASSÉ DÙ.
 LE PRÉSENT CONTRAT SERA RÉGI PAR LES LOIS DE LA PROVINCE DE QUÉBEC ET COMME
 AYANT PRIÉ NAISSANCE DANS LE DISTRICT JUDICIAIRE DE MONTRÉAL.
 ADMINISTRATION CHARGES OF 1½% PER MONTH (18% PER YEAR) ON OVERDUE ACCOUNTS.
 THE PRESENT AGREEMENT SHOULD BE GOVERNED BY THE QUEBEC LEGISLATION AND SHOULD
 BE CONSIDERED AS HAVING ORIGINATED IN THE JUDICIAL DISTRICT OF MONTREAL.

TOTAL ➡

643.00

38.58

681.58

ThyssenKrupp Acciai Speciali Terni S.p.A.
con Unico Socio
Una società della ThyssenKrupp Stainless
Viale D. Bica, 218 - 05100 Terni, Italia

14150006

**CERTIFICATO DI COLLAUDO
INSPECTION CERTIFICATE
CERTIFICATE DE RECEPTION.
ABNAHMEPRÜFZEUGNIS B***

EN 10204/3.1B

0521581

PAG

**SPECIFICA:
SPECIFICAZIONE:
ANFORDERLINO:**

ASTM A 240/01A
ASME SA 240/01

ORDRE CLIENTE N°:
CUSTOMER ORDER N°:
COMMANDE DU CLIENT N°:
BESTELLUNG N°:

1137/SM457

CLIENTE: NEW YORK
CUSTOMER: NEW YORK
CLIENT: NEW YORK

USA

ORANGE COUNTY, CALIF. 8E059217

INTERNAL ORDER NO.
COMMANDE INT NO.
WORKING

AVL DI MEDIZ. N°:
SHIPPING NOTICE N°: 00053137
AMS DESPATCH N°:
VERSANDZITUNG N°:



PRODOTTI:
PRODUCTS:
PRODUITS:
PRÜFGEGENSTÄND:

STAINLESS STEEL COILS

VERBODEN TOEGANG																
N° ROTOLA COL. N° N° BORNE RANDE.		N° COLATA VETRO N° N° COLLEE SCHMELZE N°		COMPOSIZIONE CHIMICA - CHEMICAL COMPOSITION - COMPOSITION CHIMIQUE - CHEMISCHE ZUSAMMENSETZUNG												
				% C	% Mn	% Si	% P	% S	% Cr	% Ni	% Mo	% N	% Ti	% Cu	%	%
797629		0489673		.046	1.37	.34	.029	.001	18.31	8.02	.36	.050		.400		
797628		0489673		.046	1.37	.34	.029	.001	18.31	8.02	.36	.050		.400		

TYPE D'ADDAIO:
 STEEL TYPE:
 TYPE D'ACIER:
 MARQUE DÉPOSÉE

AST 304

~~304~~
304

TINERO DEL PRODUTTORE:
PRODUCER TRADE MARK:
MARQUE DU PRODUCTEUR
ZEICHEN DER LIEFERMERS:

TIMBRE DEL RESPONSABILE INCARICATO
INSPECTOR STAMP
MARQUE DU RESPONSABLE CHARGE
STAMPFEL DES VERKEHRSSACHVERSTÄNDIGEN

80 CENTRO DI FINITURA P.F. TERNI

TRUST, TEMPOCO - NICOTYANAMIDE SULFONATE 1050°C

APR - JUNE 1972, JUNE 1972

HEAT TREATMENT - ANNEALING: AIR - WATER SPRAY - WATER COOLING
TRAITEMENT - THOMIQUE - HYPERTRÉPPE AIR - EAU AIGUISSE - EAU
WÄRMEBEHANDLUNG - ABSCHÜCKEN: "LUFT - SPRÜHWASSER - WASSER

PROCESSO DI FUSIONE E + ADD + CC
STEELMAKING PROCESS
PROCÉDE D'ÉLABORATION
EISCHMELZUNGSRHART

IL MATERIALE È RESISTENTE ALLA CORROSIONE INTERMETALLICA E IN ADOSSAMENTO.
THE MATERIAL IS RESISTANT TO INTERMETALLIC CORROSION AND ADOSSAMENTO WITH
L'INTERMETALLIC CORROSION AND ADOSSAMENTO WITH
RESISTENT TO INTERMETALLIC CORROSION AND ADOSSAMENTO WITH

ASTM A262

RISULTATO DELLE PROVE / TEST RESULTS / RESULTATS DES ESSAIS / ERGEBNIS DER PRÜFUNGEN (1 N/mm² = 1 MPa)																		
N° COLLO PACKAGE N° N° COUS KISTEN N°	N° RIFOLD COL N° N° BORME BÜCH N°	DIMENSIONI DIMENSIONS ABMESSUNGEN INCHES	N° PEZZI PIECES N° N° PEZAS STÜCKEN	FATTURA FRESH FRICTION AUFTRAG	PESO WEIGHT POIDS GEWICHT LIBRAS	C	T	TRAZIONE / TENSILE / TRACTION / ZUGVERSUCH						DUREZZA HARDNESS DURETE HÄRTE	FLEGA BEND PLIAGE KUMMERBÜCH ≈ 180°	GRAND GRAB KOPF		
								R		A %		B	C				D	E
								kg/mm²	MPa	kg/mm²	%							
CARATTERISTICHE RICHIESTE - REQUIRED CHARACTERISTICS - CHARACTÉRISTIQUES REQUISES - ANFORDERUNGEN																		
C06844	797629	0.86 X1219.2	1	2B	21671	T	T	41	96	58.0			82.0					
C06844						C	T	41	96	57.0			82.0					
C06973	797628	0.86 X1219.2	1	2B	21186	T	T	39	90	59.5			80.0					
C06973						C	T	39	90	58.3			80.0					

Confirmando che i prodotti sopra elencati sono conformi alle prescrizioni dell'ordine.
We confirm products listed above comply with order requirements.
Nous confirmons que les produits ci-dessus s'accordent avec prescriptions de la commande.
Wir bestätigen, dass die Lieferung den Vereinbarungen der Bestellung entspricht.

COMPLIES WITH ED 2000/53

ThyssenKrupp Acetal Special Term S.p.
Firma del Responsabile Incaricato
Inspector Signature
Signature du Responsable Charge
Unterzeichnet der Werkschwermetallabteilung

Certificato

1) Sampling - Location - Ort
T = Testa - Top - Tide - Kopf
G = Gode - Bottoms - Flod - Fuss

2) Genus-Direction-Föhlung
T = Transversale - Transverse - Transverse - Quers
L = Longitudinale - Longitudinal - Long - Längs

MANUFACTURE:
NATION:
LANGUAGE:
FINANCING:

Wear - Type
Heat n° - Coil N°
Thickness - Finish

TEPALLA 30-05-2005

S. S. BAIANO